

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 13.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007876**Date Inspected:** 20-Jul-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2230**Contractor:** Oregon Iron Works Clackamas, Or.**Location:** Clackamas, OR**CWI Name:** Steve Barnett**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Hinge-K Components**Summary of Items Observed:**

Summary of Items Observed: On this date, Caltrans Quality Assurance Inspector (QA) Clete Henke was present at Oregon Iron Works, Inc. (OIW) in Clackamas, OR for observation of fabrication of the Hinge K Pipe Beams and related activities including in process welding and OIW Quality Control (QC) visual and nondestructive testing. The following observations were recorded:

OIW Fabrication Shop-Bay 3**Hinge-K Pipe Beam Fuse Assembly 120A-7:**

a124-5 to a124-15

Upon arrival, the QA Inspector was informed by OIW QC Inspector Steve Barnett that assembly 120A-7 had undergone QC Ultrasonic Testing (UT) during the day shift and was available for QA UT verification. The QA Inspector performed visual testing (VT) of 100% of the complete joint penetration (CJP) weld joining a124-5 fuse section with a124-15 fuse section identified as WM3-18 prior to performing UT verification. The QA Inspector noted that the above identified weld joint appeared to be in general compliance with the contract requirements. The QA Inspector performed UT of approximately 10% of the above identified CJP weld joint, locating no rejectable indications per AWS D1.5 2002, Table 6.3 -Tensile Stress. Please reference TL-6027 for this date for additional information. The QA Inspector marked the adjacent areas accordingly.

Hinge-K Pipe Beam Fuse Sub-Assembly 120A-8:

A124-16 to a124-8

The QA Inspector observed no production activity on the assembly noted above for the duration of the shift.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Hinge-K Pipe Beam Base Assembly 102A-1:

a111-1 forging to a110-4 base plate

The QA Inspector observed no production activity on the assembly noted above for the duration of the shift.

Hinge-K Pipe Beam Base Assembly 102A-4:

a111-4 forging to a110-4 base plate

The QA Inspector intermittently monitored OIW personnel as they ground weld access hole areas on completed welds. No production welding was performed during this shift.

OIW Fabrication Shop-Bay 6

Hinge-K Pipe Beam Fuse Assembly 120A-1:

a124-6 to a124-7

The QA Inspector observed no production activity on the assembly noted above for the duration of the shift. OIW QC Inspector Steve Barnett indicated that OIW production intended to suspend production welding on the Electro Slag Welding (ESW) Corrosion Resistant Overlay (CRO) until one of the previously completed assemblies undergoes final machining.

Hinge-K Pipe Beam Fuse Assembly 120A-2:

a124-3 to a124-11

The QA Inspector observed no production activity on the assembly noted above for the duration of the shift.

Hinge-K Pipe Beam Fuse Assembly 120A-4:

a124-4 to a124-13

The QA Inspector observed no production activity on the assembly noted above for the duration of the shift.

Hinge-K Pipe Beam Fuse Assembly 120A-5:

a124-14 to a124-2

The QA Inspector observed no production activity on the assembly noted above for the duration of the shift.

Hinge-K Pipe Beam Fuse Sub-Assembly 120A-6:

A124-9 to a124-1

The QA Inspector observed no production activity on the assembly noted above for the duration of the shift.

Material, Equipment, and Labor Tracking:

The QA Inspector performed verification of personnel involved with this project and equipment in use. The QA Inspector accounted for 2 OIW production personnel and 1 Quality Control Inspector present on this date.

Summary of Conversations:

As noted in the body of the report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mohammad Fatemi (916) 813-3677 , who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By: Henke,Clete

Quality Assurance Inspector

Reviewed By: Adame,Joe

QA Reviewer